

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000166**Date Inspected:** 09-Apr-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 730**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Benicia, CA.

CWI Name:	Mike Johnson		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No
Rod Oven in Use:	Yes	No
Weld Procedures Followed:	Yes	No
Verified Joint Fit-up:	Yes	No
Approved WPS:	Yes	No
Delayed / Cancelled:	Yes	No

Bridge No: 34-0006**Component:** Procedure Qualification Record (PQR) Test**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector Robert Mertz was present at the Ironworkers Apprenticeship Training Facility as requested by American Bridge/ Fluor for the continuing purpose of witnessing Procedure Qualification Record (PQR) tests. The following items were observed:

1. The Caltrans QA inspector observed the welder, Dan Gordon practicing and the Smith Emery Certified Welding Inspector (CWI) QC inspector setting up the welding parameters on a steel plate prior to starting the PQR test plate.

2. The observation is a continuance of a PQR test identified as ABF-PQR-002-1. This PQR test was welded in the vertical (3G) position, and is a single-vee groove with 25mm (1) thick A709, Grade 345W steel plate and a 10mm (3/8) thick steel backing bar per Figure 5.1 and is being welded per AWS D1.5, 2002, section 5.13.

3. The Caltrans QA inspector observed ABF Welding Superintendent Mr. Tommy Gibson was present.

4. The Caltrans QA inspector visually observed that seven self-shielded flux cored arc welding (FCAW-S) fill passes were added to the PQR test plate assembly on this date using Lincoln NR-232 wire. The welder also ground an area to prepare a groove and then apply a weld bead that was approximately 1.5 mm lower than the base metal 190 mm long. Welding of this PQR test plate was completed on this date. The weld was also ground smooth and flush as defined per D1.5. The weld tabs and strong-backs were not removed on this date.

For additional information and specific welding parameters recorded during this procedure qualification record test

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

see the Caltrans TL-6032 generated for this date. Digital pictures of observations are available upon request.

Summary of Conversations:

Mr. Tommy Gibson stated additional PQR testing would resume on Tuesday 04-10-2007.

The QC inspector stated the test plate would be RTd in San Francisco and mechanical tests will be done in Los Angeles.

The QA inspector informed the QC inspector to have ABF QCM, Jim Bowers provide the Charpy impact test temperature and energy values needed. The QA inspector also informed the QC inspector the test is per Figure 5.1 of D1.5, 2002 and Table 4.2 and or section 12 may apply, however the special provisions may requires something different which would supersede the code such as heat affected zone impact tests with different test temperatures and energy values.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Mertz,Robert	Quality Assurance Inspector
----------------------	--------------	-----------------------------

Reviewed By:	Smith,Ryan	QA Reviewer
---------------------	------------	-------------
